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D3403-1

Job Sheet 181447



Part No: D3403-1

Job Qty: 10 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3403 REV F IPP Rev:A 05.08.31 New issue KJ/JLM IPP Rev:B 06-03-07 As per Rev B JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		7/31/18	0.00	0.00	Start Up Machining-2		<i>13/07/26</i>
100	Hardinge	10 pcs		7/31/18	0.08	1.29	Hardinge		<i>12/07/26</i>
120	QC	10 pcs		7/31/18	0.00	0.00	QC8		<i>18/07/26</i>
130	Packaging	10 pcs		7/31/18	0.00	0.00	Packaging3-1	<i>56033</i>	<i>DAS 6 JUL 31 2018</i>
140	QC21-SA	10 Ea		7/31/18	0.00	0.00	QC21		<i>DAS 21 3-85 AUG 01 2018</i>

Part Op 100 - 1- Turn as per Folio FA556 & Dwg D3403 Folio Rev: AA Dwg Rev: F

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.750	303 Round Bar 0.750	2.1700 ft (.217 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R0.750	2	87	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	2.360inches + 0.010 - 0.000	2.370 2.360		
2	Bushing	0.060inches ± 0.005	0.065 0.055		
3	Bushing	0.257inches + 0.010 - 0.000	0.267 0.257		
4	Bushing	0.750inches ± 0.010	0.760 0.740		
5	Bushing	0.425inches + 0.000 - 0.002	0.425 0.423		
6	Bushing	0.030inches ± 0.010	0.040 0.020		
7	Bushing	20.0Degrees ± 0.5	20.5 19.5		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

8	Bushing	0.313inches $\pm$ 0.010	0.323 0.303
9	Bushing	60.0Degrees $\pm$ 0.5	60.5 59.5

Plex 7/26/18 11:21 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Re Use Suspected Unapp
Part No. _____	
NCR No. _____	

Date : _____ Step #: _____

Description Work Order Deviation

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QC / QA Coordinator
Approval

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

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Container No: S096678

Part: D3403-1

Job No: 181447

Serial No/Batch: S096678

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/26/18